

4 w/o's attached

Dart Aerospace Ltd.

Date: Thursday, 21/08/2008 5:12:51 PM
 User: Julie Lecocq

Process Sheet

Customer:	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SQUARE TUBE
Job Number	: 41557		
Estimate Number	: 13424		
P.O. Number	:	Part Number	: PB6743001139
This Issue	: 21/08/2008 S.O. No. :	Drawing Number	: B6743001 P.21
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 40601	Material	:
Written By	:	Due Date	: 18/09/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>JLD 08.8.22</u>		
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6TS1000W125	6061T6 SQ TUBE 1.00 x 1.00 x .125w



Comment: Qty.: 1.0542 f(s)/Unit Total: 21.0840 f(s)
 6061T6 SQ TUBE 1.00X.125
 batch: M109857

08-09-10 20

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

*1- cut to length as per dwg
 2- make a 0.090" chamfer on both ends of tube
 3- deburr

08-09-10 20

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/09/11 (x20)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: 128

08/9/12

(x20)

SCD

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/09/12

Job Completion



MF 08-09-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

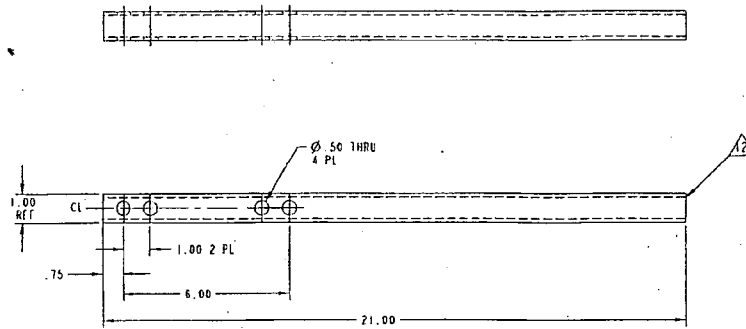
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

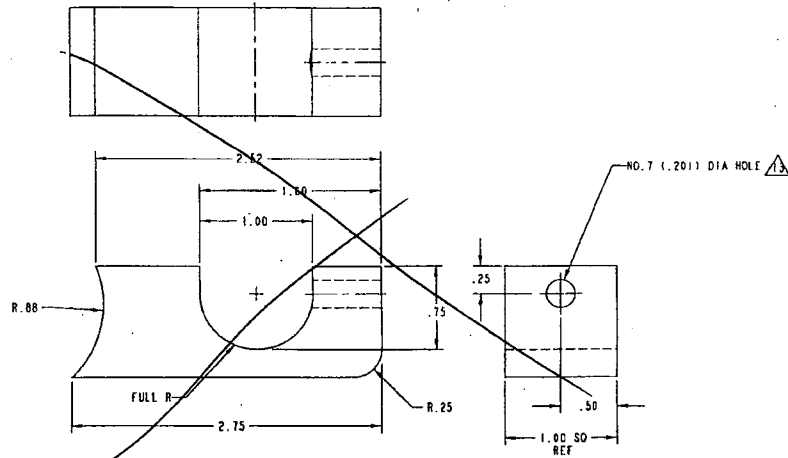
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
406-4-20

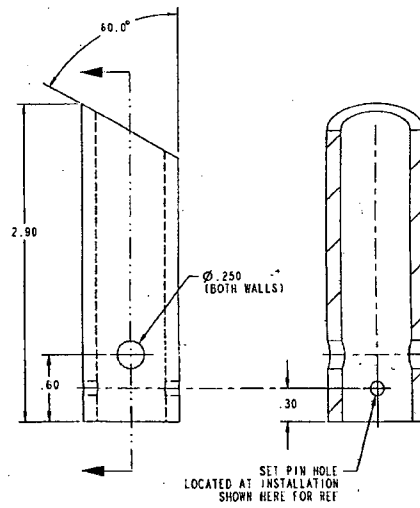


① -239 SQUARE TUBE
MATL: 1.00 SQ X .125 WALL, 6061-T6
00-A-200/8
SCALE 0.500

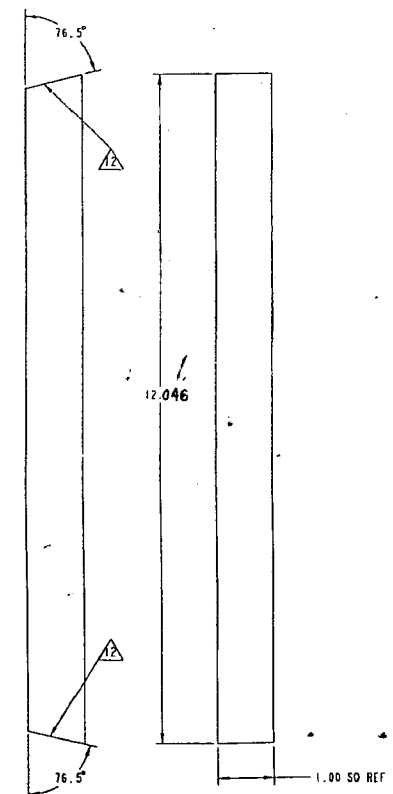


① -241 TUBE DETENT CLIP
MATL: 1.00 SQ, 6061-T6
00-A-200/8
SCALE 2.000

SUPERCEDED BY
① 03440-9



① -243 TUBE HANDLE EXTENSION
MATL: .875 OD X .125 WALL, 6061-T6
00-A-200/8
SCALE 2.000



① -139 SQUARE TUBE
MATL: 1.00 SQ X .125 WALL, 6061-T6
00-A-200/8
SCALE 1.000

PREMIER AVIATION, INC.
3002 Aviation Parkway, Grand Prairie, Texas 75052
SIZE CODE DESIG NO. DATE BY
DIOSUV8 B67-43001 84
SCALE: 1:1 SHEET 21 OF 45

ORIGINAL

NO. 4153
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SHOOT COPY

Date: Thursday, 17/07/2008 1:50:03 PM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SQUARE TUBE
Job Number	: 40601		
Estimate Number	: 13424		
P.O. Number	:	Part Number	: PB6743001139
This Issue	: 17/07/2008 S.O. No. :	Drawing Number	: B6743001 P.21
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 40500	Material	:
Written By	:	Due Date	: 24/07/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>MF 08-07-17</u>		
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6TS1000W125	6061T6 SQ TUBE 1.00 x 1.00 x .125w

Comment: Qty.: 1.0542 f(s)/Unit Total: 5.2710 f(s)
6061T6 SQ TUBE 1.00X.125
batch: M186002



MF 08-07-16 5

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1



1- cut to length as per dwg
2- make a 0.090" chamfer on both ends of tube
3- deburr

MF 08-07-16 5

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP



800/7/17 (x5)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: WA



MF 08-07-16 5

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE



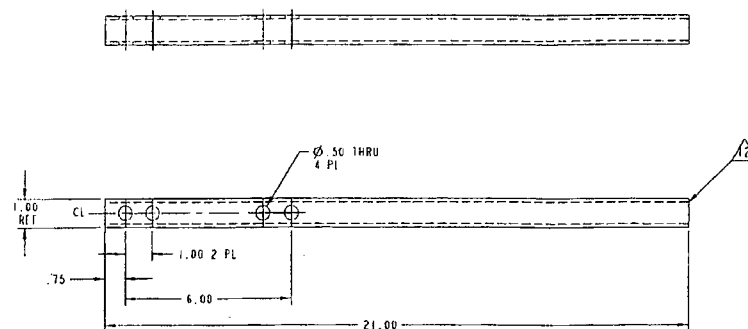
08/07/18

Job Completion

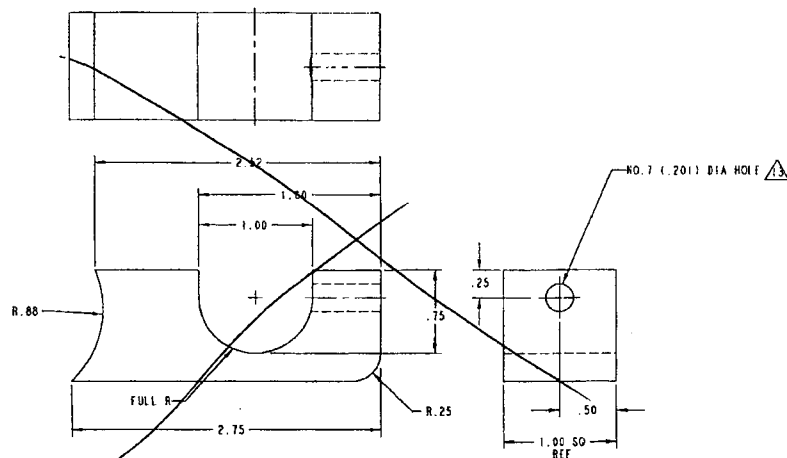


MF 08-07-18

RELEASED
#40601-20



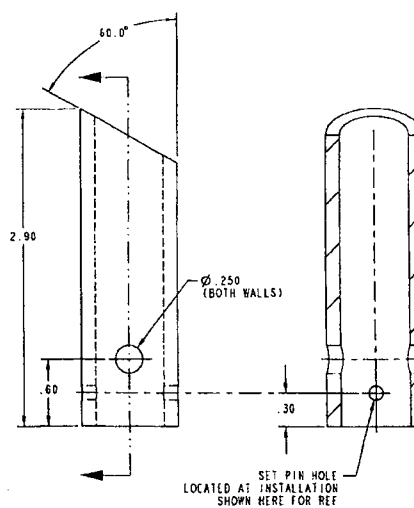
① -239 SQUARE TUBE
MTRL: 1.00 SQ X .125 WALL, 6061-T6
QD-A-200/8
SCALE: 0.500



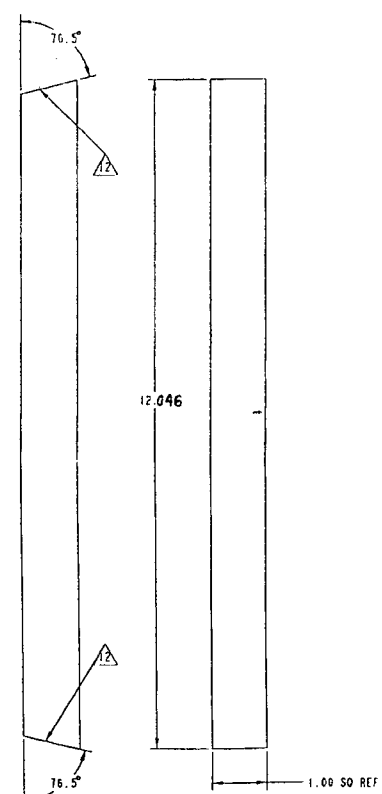
① -241 TUBE DETENT CLIP
MTRL: 1.00 SQ, 6061-T6
QD-A-200/8
SCALE: 2.000

SUPERCEDED BY

① 23440-9



① -243 TUBE HANDLE EXTENSION
MTRL: .875 OD X .125 WALL, 6061-T6
QD-A-200/8
SCALE: 2.000



① -139 SQUARE TUBE
MTRL: 1.00 SQ X .125 WALL, 6061-T6
QD-A-200/8
SCALE: 1.000

#40601

PREMIER AVIATION, INC.
3001 Aviation Parkway, Grand Prairie, Texas 75052
SIZE: CODE: REV: NO. 81
D: OSUV8 B67-43001
DATE: 81 SHEET: 21 OF 45

ORIGINAL